

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave.St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-006164**Date Inspected:** 08-Apr-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1830**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 630**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	Guo Peng and Zhao Chen Sun			<b>CWI Present:</b>	<b>Yes</b>	<b>No</b>	
<b>Inspected CWI report:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Rod Oven in Use:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Electrode to specification:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Weld Procedures Followed:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Qualified Welders:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Verified Joint Fit-up:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Approved Drawings:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Approved WPS:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
				<b>Delayed / Cancelled:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>

**Bridge No:** 34-0006**Component:** Tower and OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Joe Alaniz was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

**Bay 5**

This QA inspector performed UT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member(s) is/are identified as Bike Path. The weld designations reviewed are as follows:

1. BK001-005-001~004
2. BK001-005-008~010

**Bay 6**

This QA Inspector observed the following work in progress:

FCAW welding of weld joint 4B located on PCMK WSD1-DPSA4-15.

Welder is identified as Mr. Li Shugia (053609). ZPMC QC is identified as Zhao Chen Sun.

The welding variables recorded by QC appeared to comply with WPS-B-T-2233-B-U3-F.

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

---

FCAW welding of weld joint 2A located on PCMK ESD1-DPSA4-15.

Welder is identified as Mr. Lei Weiwen (019006). ZPMC QC is identified as Zhao Chen Sun.

The welding variables recorded by QC appeared to comply with WPS-B-T-2233-B-U3-F.

Bay 14

This QA Inspector observed the following work in progress:

FCAW welding of weld joint 004 located on PCMK CA33B.

Welder is identified as Mr. Wu Wan Yong (050242). ZPMC QC is identified as Shi Lei.

The welding variables recorded by QC appeared to comply with WPS-B-T-2232-Tc-U4b-F.

SMAW welding of weld joint 004 located on PCMK SEG028\*.

Welder is identified as Mr. Yang Gen Chen (219188). ZPMC QC is identified as Shi Lei.

The welding variables recorded by QC appeared to comply with WPS-B-T-2233-B-U2-F.

SAW welding of weld joint 006 located on PCMK SEG031\*.

Welder is identified as Mr. Wang Lanying (045265). ZPMC QC is identified as Shi Lei.

The welding variables recorded by QC appeared to comply with WPS-B-T-2221-B-L2c-S-2.

Bay 13

This QA Inspector observed the following work in progress:

SMAW welding of weld joint 004 located on PCMK SEG007A.

Welder is identified as Mr. Ren Jinzhu (044772). ZPMC QC is identified as Shi Lei.

The welding variables recorded by QC appeared to comply with WPS-B-P-2114-Tc-U4b-FCM.

Bay 11

This QA Inspector observed the following work in progress:

SMAW welding of weld joint 26A located on PCMK WSD1-FCAS3-2B/C.

Welder is identified as Mr. Wang Jintao (205679). ZPMC QC is identified as Guo Peng.

The welding variables recorded by QC appeared to comply with WPS-B-T-2311-B-P3 and WPS-B-T-2311-B-P3.

SMAW welding of weld joint 28A located on PCMK WSD1-FCAS3-2B/C.

Welder is identified as Mr. Chen Kang (206195). ZPMC QC is identified as Guo Peng.

The welding variables recorded by QC appeared to comply with WPS-B-T-2311-B-P3 and WPS-B-T-2311-B-P3.

SMAW welding of weld joint 28A located on PCMK WSD1-FCAS3-2B/C.

---

## WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

---

Welder is identified as Mr. Chen Kang (206195). ZPMC QC is identified as Guo Peng.  
The welding variables recorded by QC appeared to comply with WPS-B-T-2311-B-P3 and WPS-B-T-2311-B-P3.

Bay 10

This QA Inspector observed the following work in progress:

FCAW welding of weld joint 7 and 8 located on PCMK NSD1-TL8H/L.

Welder is identified as Mr. Yu Chaoye (053869). ZPMC QC is identified as Liu Liang.

The welding variables recorded by QC appeared to comply with WPS-B-T-4132.

FCAW welding of weld joint 54 located on PCMK WD1-A22A/B.

Welder is identified as Mr. Yu Yonglai (048378). ZPMC QC is identified as Jin Dong Liang.

The welding variables recorded by QC appeared to comply with WPS-B-T-2332-Tc-P5-F.

FCAW welding of weld joint 53 located on PCMK WD1-A22A/B.

Welder is identified as Mr. Jin Xiaogang (053869). ZPMC QC is identified as Jin Dong Liang.

The welding variables recorded by QC appeared to comply with WPS-B-T-2332-Tc-P5-F.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (134-8257-0045), who represents the Office of Structural Materials for your project.

---

<b>Inspected By:</b>	Alaniz,Joe	Quality Assurance Inspector
<b>Reviewed By:</b>	Carreon,Albert	QA Reviewer

---